

Date: Wednesday, 20/05/2009 1:53:18 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 48090C					
Estimate Number	: 10356					
P.O. Number	:			Part Number	: D2279	
This Issue	: 20/05/2009		S.O. No. :	Drawing Number	: D2279 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	: 47644C			Material	:	
Written By	:			Due Date	: 27/05/2009	
Checked & Approved By	: MF 09-05-21			Qty:	10 Um: Each	
Comment	: Est Rev: A New Issue 05-11-07 JLM					
	Est Rev:B Now on Waterjet 06-07-03 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
		Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.5435 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: 111786 <b>BS 9-6-24</b>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D 2279 Dwg Rev: <b>D</b> <b>BS 9-6-24</b> Prog Rev: <b>D</b>	<b>18</b>
		2-Deburr if necessary	<b>BS 9-6-24</b>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<b>BS 9-6-24</b>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<b>S 09/06/24</b>
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form As per Dwg D2279	<b>BS 09/06/24</b> <b>18</b> <b>BS 09/07/01</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 48090C

Part Number: D2279

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50916B101 X18

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



X18

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1000 09107101

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-07-01

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

AS Tevren

PC 9/7/2 (18)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



0910710701

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 09.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>48090C</b>
<b>Description:</b> Step Spacer	<b>Part Number:</b>	<b>D2279</b>
<b>Inspection Dwg:</b> D2279 <b>Rev:</b> D		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	BS	Audited by:	S	Prototype Approval:	N/A
Date:	9-6-24	Date:	21/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

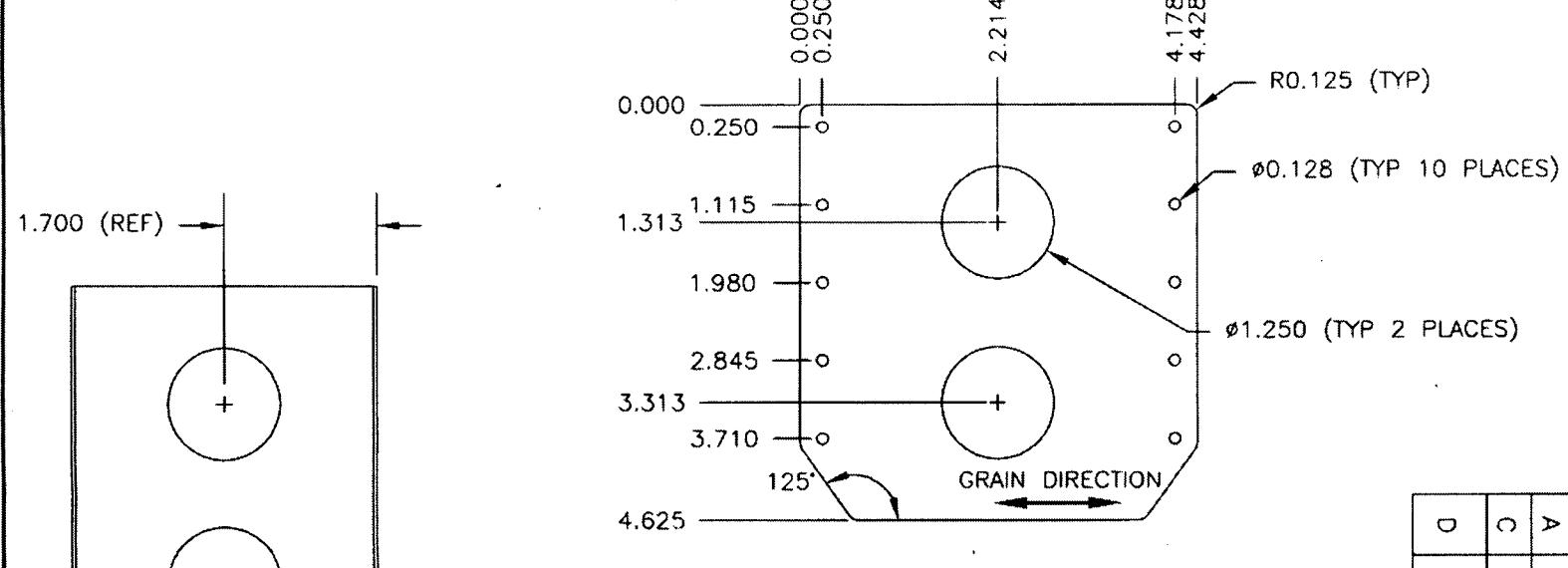
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN BY	DRAWN BY	DART AEROSPACE LTD
REVIEWED BY	APPROVED BY	HAWKESBURY, ONTARIO, CANADA
DATE	REVISION	REV. D
98.10.05	18.10.05	1.0
A	94.10.13	NEW ISSUE
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912



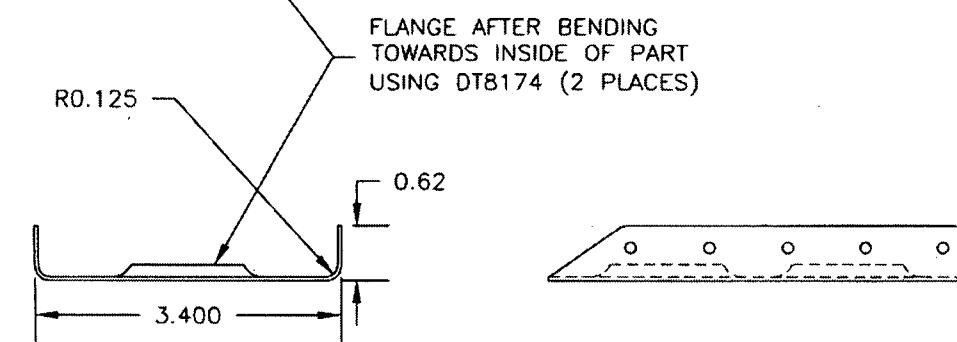
RELEASER

18.10.05 DS

15.10.94

DESIGNER: D. B. C. FOR CHECK WITH

BEFORE MANUFACTURE



*#48090C*

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries